

Work Order ID 64254

Tuesday, November 30, 2010 4:07:27 PM



Page 1

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Lid Assembly (350)

Start Date: 11/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 12/10/2010 Req'd Qty: 1.00



Customer:

Reference:

10-01-12

Approvals:

Process Plan:

PL

Date:

10/1/12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3914

B

100

Weld per dwg A/R S.S. rod Batch: *1114649* 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D3914 using DT9607A
2- weld hinge (3) and Mounting brackets as per dwg D3914
inspect before welding mesh
3- tack weld mesh on basket as per dwg D3914
***make sure to place mesh correctly on lid, check with label plate before
tacking mesh***

11/01/03

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

11-01-03

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Cust Item ID:

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Customer:

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Date:

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

8/10/10



QC

Memo

0.00

Quality Control

(+)

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

M 112588



Powdercoat

Memo

0.00

Powder Coating

*** mask sides of hinge prior to powdercoat***

Start Time: *7:25*

Oven Temperature: *320°*

Finish Time: *8:00*

1 11-01-3

140

Wing Walk as per dwg QSI005 4.4 Batch *11157900*

0.00

del 10/01/01



HandFinish

Memo

Hand Finishing

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- Install placard and label as per dwg

1

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Item ID: D3914-041

Accept

Setup Start

Revision 'D':

Stop

Item Name: Long Basket Lid Assembly (350)

Start Date: 11/30/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 12/10/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: B64 2520.00

0.00



Packaging

Memo

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

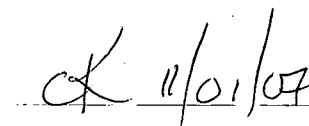


QC

Memo

0.00

Quality Control



mf
11-01-07

Picklist Print

Tuesday, November 30, 2010 4:07:32 PM

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3

Work Order ID: 64254

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 11/30/2010

Required Date: 12/10/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D2581
Mounting Bracket

Manufactured No

100

Each

23.0000

2

2

Location

Loc Qty

Loc Code

WA

23

61953

20

63493

3

✓ D3914-1
Rib

Manufactured No

100

Each

2.0000

2

2

Location

Loc Qty

Loc Code

WA

2

63609

2

✓ D3914-7
Rib

Manufactured No

100

Each

2.0000

2

2

Location

Loc Qty

Loc Code

WA

2

63631

2

✓ D4016-3
Hinge Half, Lid

Manufactured No

100

Each

7.0000

3

3

Location

Loc Qty

Loc Code

WA

7

63256

1

63855

6

B64425 @ 10/12/23

B64138 2x 10/12/23

B64137 2x 10/12/23

10/12/23

3x

Picklist Print

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Page 2

3

Work Order ID: 64254



Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 11/30/2010

Required Date: 12/10/2010

Start Qty: 1.00

Required Qty: 1.00

✓

D4018-5

Manufactured No

100

Each

43.0000

9

9



Rib



10/12/23

Location

Loc Qty

Loc Code

WA

43

63610

24

64067

19

9

✓

D4020-5

Manufactured No

100

Each

1.0000

1

1



Mesh (350 Basket Long, Lid)



B63684 - 1x

11/01/03

Location

Loc Qty

Loc Code

WA

1

60643

1

D4021-3

Manufactured No

100

Each

2.0000

1

1



Data Plate



B64848 1x 11/01/03

Location

Loc Qty

Loc Code

WA

2

56050

1

63611

1

✓

D4035-041

Manufactured No

100

Each

2.0000

1

1



Lid Rib Assembly, Fwd (350 Basket)



10/12/23

Location

Loc Qty

Loc Code

WA

2

63612

2

1x

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Shop Packet Print

Page 2

Picklist Print

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Page 3

3

Work Order ID: 64254

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 11/30/2010

Required Date: 12/10/2010

Start Qty: 1.00

Required Qty: 1.00

✓

D4035-043

Manufactured No

100 Each

2.0000

1

1



Lid Rib Assembly, Aft (350 Basket)



10/12/23

Location

Loc Qty

Loc Code

WA

2

63613

2

D2728-3

Manufactured No

140 Each

0.0000

1

1



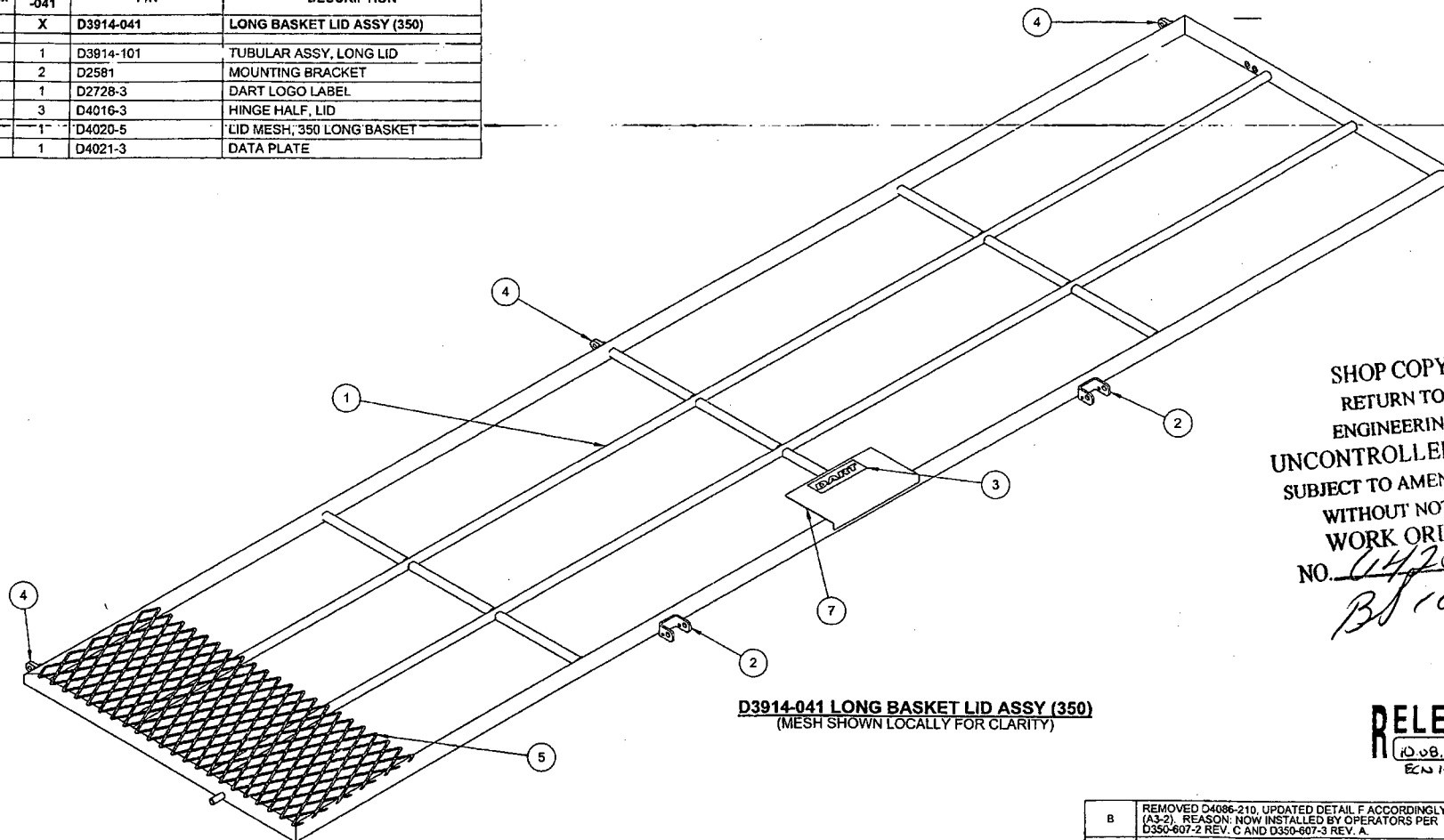
Dart Logo label



11

M115050 11/01/08

ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE

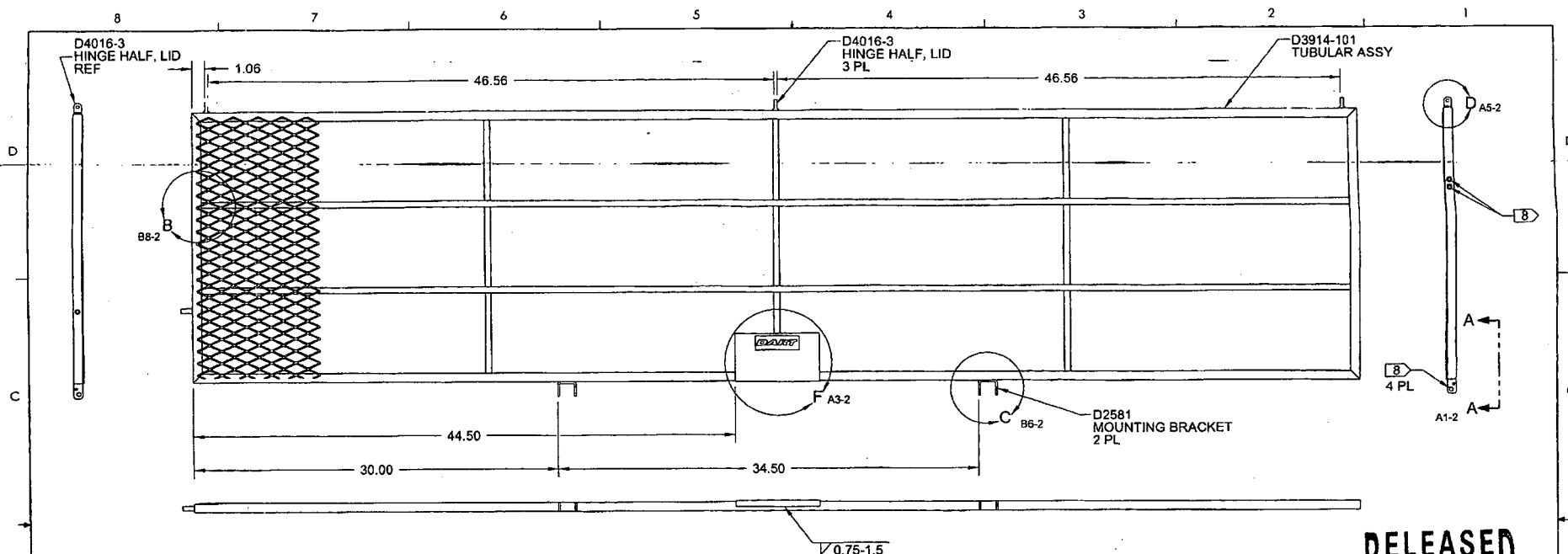


D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *04254*
BS 10-01-12

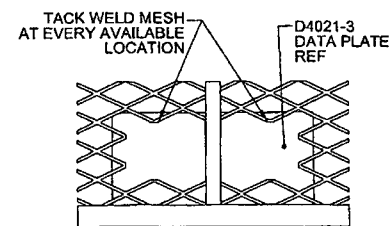
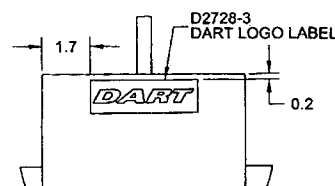
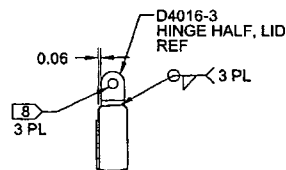
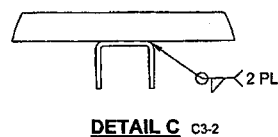
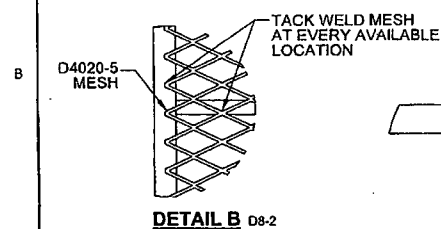
RELEASED
10.08.17
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>ALS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>SC</i>		
CHECKED	<i>SC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>ALS</i>	D3914	SHEET 1 OF 4
APPROVED	<i>ALS</i>	TITLE	SCALE
DE APPR.	<i>ALS</i>	LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



RELEASED
10.08.12 up

D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

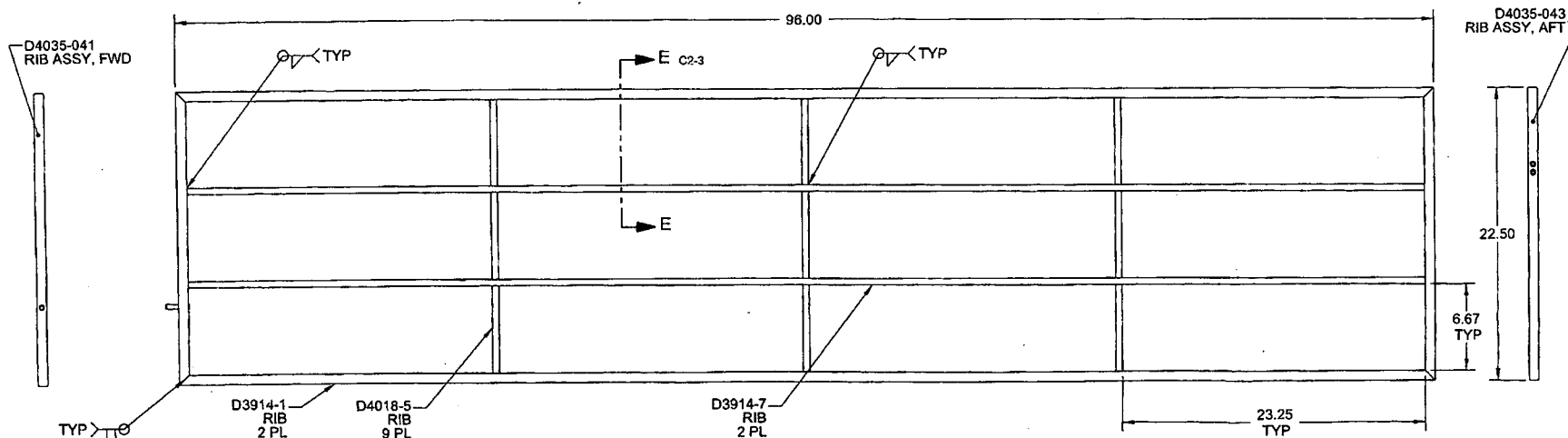
DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO.	REV. B
CHECKED	WJ	D3914	SHEET 2 OF 4
MFG. APPR.		TITLE	SCALE
APPROVED		LONG BASKET LID ASSY (350)	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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w/o 64254

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



8 D3914-101 TUBULAR ASSY, LONG LID

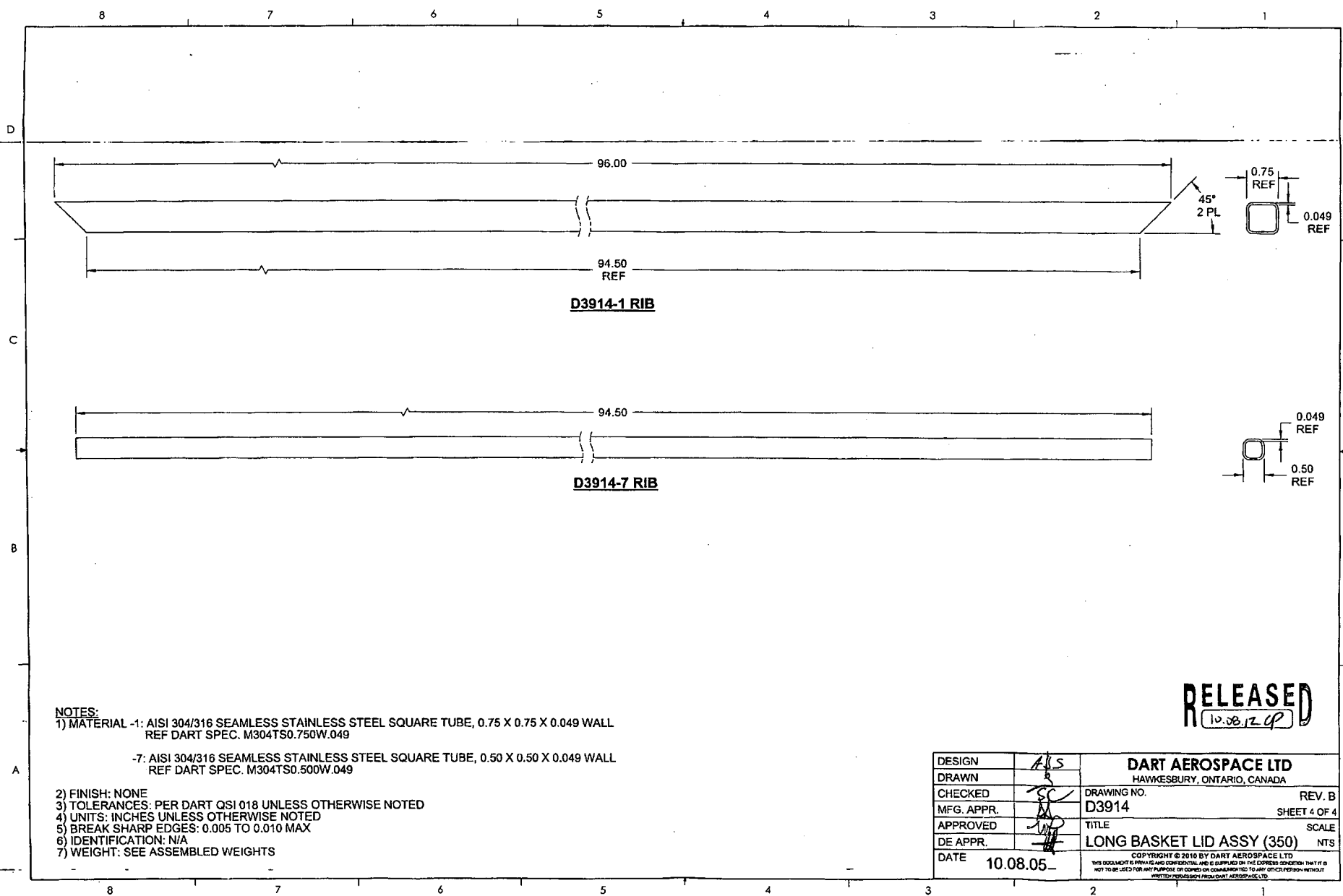
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

RELEASED
10-28-12

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	AC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AC	DRAWING NO. D3914	REV. B
MFG. APPR.	AC		SHEET 3 OF 4
APPROVED	AC	TITLE	SCALE
DE APPR.	AC	LONG BASKET LID ASSY (350)	NTS
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w/o 44234



NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
10.08.12 LP

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	MP	D3914	SHEET 4 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	LONG BASKET LID ASSY (350)	NTS
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w/0 44254